

# Work Order ID 95662

January-16-13 10:24:59 AM

\*95662\*

Page 1

Item ID: D4464-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fuel Tank Assembly

Start Date: 1/16/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 2/08/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N):\* \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D4464 D

100 Weld per dwg A/R Aluminum rod Batch: 122324 0.00  
123928

\*100\*

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5- Weld D4463-7 fwd end

\*\*\*PURGE INSIDE OF TANK\*\*\*

**Achtung!**  
Vor Einbau Sicherungstift herausnehmen  
**Attention,**  
remove safety pin before installation  
**Atenção!**  
Remova o pino de segurança antes de montar

13-04-16

# Work Order ID 95662

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Item ID: D4464-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Tank Assembly  
 Start Date: 1/16/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 2/08/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	Memo	0.00							DAS 09 2-83
Quality Control									
120	Weld per dwg A/R Aluminum rod Batch: <u>M125127</u>	0.00							
<b>*120*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Weld top D4463-1 using DT9811 and DT9810								
	***PURGE INSIDE OF TANK***								
123	QC5- Inspect part completeness to step on W/O	0.00							
<b>*123*</b>									
QC	Memo	0.00							DAS 27 2-83 13425
Quality Control	***Pressure Test as per dwg D4464***								

**\*95662\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*1\***

**Cust Item ID:**

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

0.00

**\*150\***

HandFinish

## Memo

0.00

## Hand Finishing

1- brush alodine on tank. No alodine inside

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

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Item ID: D4464-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fuel Tank Assembly  
 Start Date: 1/16/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 2/08/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00

\*170\*

Powdercoat

Powder Coating

Memo

\*\*\*Mask prior to powdercoat\*\*\*

POWDER COAT ANSL61 GREY AS PER DWG AND QSI 005 4.3

Start Time: 8:30

Oven Temperature: 320 F

Finish Time: 9:00

1X M / 13/04/26

180

0.00

\*180\*

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

1X d 13/04/26

M118533

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Item ID: D4464-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 2/08/13

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

0.00

**\*190\***

Small Fab

Memo

0.00

Small Fab

1- Mask off area, where access cover is applied

2- Abrade surface with red scotch brite

3- Wipe with clean cloth and wash and wipe

4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with  
proseal 890

A/R proseal 890 Batch:

M124856

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

DAS  
27  
28

13430

1

13/04/13

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Item ID: D4464-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 2/08/13

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

13/5/2013  
006  
8-813/5/13  
mf

13-5-02

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Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER  
DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 Placard		Manufactured	No			190	Each	94.0000	2	2	SP		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST243		94							
				72611		75			2x				
				81028		4							
				83650		6							
				87530		9							
D3997-11 Placard		Manufactured	No			190	Each	8.0000	1	1	SP		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Return2012		1							
				80308		1							
				ST243		7							
				82957		7			1x				
D3997-17 Placard		Manufactured	No			190	Each	10.0000	1	1	SP		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST243		10							
				82958		10			K				
D3997-29 Placard		Manufactured	No			190	Each	9.0000	1	1	SP	13-4-29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST243		9							
				80845		9			1x				

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Work Order ID: 95662

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D3997-43 Placard	Manufactured	No	190	Each	9.0000	1	1	Sp
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST243	9				
			80310	1				
			82960	8				
D3999-7 Corner	Manufactured	No	100	Each	6.0000	1	1	IX 13.04.16
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003	6				
			71695	1				
			86021	5				
D3999-9 Angle	Manufactured	No	100	Each	5.0000	1	1	13.04.15
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003 399497	5				
			82545	1				
			86022	4				
D3999-11 Earth Tab	Manufactured	No	100	Each	13.0000	1	1	13.04.16
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003	13				
			84161	13				
D4000-1 Fuel Supply Fitting	Manufactured	No	100	Each	4.0000	1	1	13.04.16
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003 396197	4				
			83811	4				
D4000-5 Fuel Tank Vent Fitting	Manufactured	No	100	Each	2.0000	1	1	13.04.16
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003 095633	2				
			83813	2				

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Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4000-9 Manufactured No 100 Each 13.0000 3 3 13-04-15

Grommet

Location	Loc Qty	Loc Code
WA003 <u>396195</u>	13	
83814	2	
85907	11	

3

D4000-045 Manufactured No 100 Each 6.0000 1 1 13-04-16

Fuel Pickup Fitting Assembly

Location	Loc Qty	Loc Code
WA003 <u>397582</u>	6	
71669	1	
72078	1	
90582	4	

1

D4008-11 Manufactured No 100 Each 3.0000 1 1 13-04-15

Hinge Half

Location	Loc Qty	Loc Code
WA003 <u>395645</u>	3	
80037	1	
80838	2	

1

\* D4008-041 Manufactured No 190 Each 6.0000 1 1 13-04-30

Fuel Filler Splash Guard Assembly

Location	Loc Qty	Loc Code
ST142	6	
84013	1	
85041	5	

1

13-04-30  
39183 (100)

D4023-3 Manufactured No 190 Each 11.0000 1 1 13-04-15

Cap and Flange

Location	Loc Qty	Loc Code
WA003	11	
81898	3	
84422	8	

1

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Work Order ID: 95662

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4025-5 Manufactured No 190 Each 5.0000  
Fuel Quantity Sender

1 1 SP

Location	Loc Qty	Loc Code
ST141	5	
81899	1	
84421	4	

D4057-1 Manufactured No 100 Each 10.0000  
Retaining Ring

3 3 13.04.15

Location	Loc Qty	Loc Code
WA003 895809	10	
83656	10	

D4062-041 Manufactured No 190 Each 6.0000  
Tank Support Assembly

1 1 13.04.30

Location	Loc Qty	Loc Code
WA003	6	
86024	6	

D4124-1 Manufactured No 100 Each 15.0000  
Tab

4 4 13.04.23

Location	Loc Qty	Loc Code
WA003 397571	15	
83824	1	
93815	14	

D4125-1 Manufactured No 100 Each 7.0000  
Sump

1 1 13.04.15

Location	Loc Qty	Loc Code
ST150	5	
90234	5	
WA003	2	
83825	1	
86060	1	

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Work Order ID: 95662

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4125-3	Manufactured	No	100	Each	7.0000	1	1	<i>K13-04-15</i>
End								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA003	7					
		83826	1					
		86061	1					
		<u>90235</u>	5					
D4404-3	Manufactured	No	100	Each	1.0000	1	1	<i>B957138P</i>
Cushion, Side								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST143	1					
		88191	1					
D4404-5	Manufactured	No	100	Each	9.0000	4	4	<i>B975648P</i>
Cushion, Fwd								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST143	9					
		87501	3					
		90553	6					
D4462-1	Manufactured	No	100	Each	5.0000	1	1	<i>K13-04-15</i>
Baffle								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA003	5					
		84353	2					
		<u>89923</u>	3					
D4462-3	Manufactured	No	100	Each	5.0000	1	1	<i>K13-04-15</i>
Baffle								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		WA003	5					
		<u>89924</u>	5					

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Work Order ID: 95662

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4463-041 Tank Top Assembly Manufactured No 120 Each 8.0000 1 1 *13.04.16*

Location	Loc Qty	Loc Code
WA003	8	
84364	4	
92263	4	

D4463-3 Tank Aft End Manufactured No 100 Each 6.0000 1 1 *13.04.16*

Location	Loc Qty	Loc Code
WA003	6	
89919	6	

D4463-5 Tank Upper Cut Out Manufactured No 100 Each 5.0000 1 1 *13.04.16*

Location	Loc Qty	Loc Code
WA003 <i>B99498</i>	5	
76906	1	
83834	4	

D4463-7 Tank Fwd End Manufactured No 100 Each 5.0000 1 1 *13.04.16*

Location	Loc Qty	Loc Code
WA003	5	
88564	1	
89918	4	

D4463-9 Tank Back Manufactured No 100 Each 6.0000 1 1 *13.04.16*

Location	Loc Qty	Loc Code
WA003	6	
89920	6	

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Work Order ID: 95662

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4463-11 Tank Front      Manufactured      No      100      Each      6.0000      1      1      *1/13-04-15*

Location	Loc Qty	Loc Code
WA003	6	
88021	1	
89921	5	

D4463-13 Tank Bottom      Manufactured      No      190      Each      9.0000      1      1      *1/13-04-15*

Location	Loc Qty	Loc Code
WA003	9	
82237	2	
83831	1	
86575	2	
89922	4	

AN3H5A Bolt      Purchased      No      190      Each      24.0000      5      5      *SP*

Location	Loc Qty	Loc Code
ST350	24	
120693	4	
122800	20	

MS21042L3 Nut      Purchased      No      190      Each      4,071.0000      4      4      *2x M124805*

Location	Loc Qty	Loc Code
FP001	10	
122141	10	
GA	446	
122452	446	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3347	
123900	3347	

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Parent Item: D4464-041

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Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

MS35206-266

Purchased

No

190

Each

174.0000

4

4

Screw

Location

Loc Qty

Loc Code

ST289

174

119850

74

123168

100

NAS1149D0363J

Purchased

No

190

Each

1,270.0000

37

37

Washer

Location

Loc Qty

Loc Code

FP001

9

123248

9

ST294

1261

122378

663

123355

598

AN3-4A

Purchased

No

190

Each

545.0000

24

24

Bolt

Location

Loc Qty

Loc Code

ST350

195

120308

80

122814

115

ST512

350

120770

200

123900

150

D4577-1

Manufactured

No

190

Each

3.0000

1

1

Rear Access Panel

Location

Loc Qty

Loc Code

ST142

3

86085

3

D4577-3

Manufactured

No

190

Each

3.0000

1

1

Middle Access Panel

Location

Loc Qty

Loc Code

WA003

3

86086

3

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Start Date: 1/16/13

Required Date: 2/08/13

Start Qty: 1.00

Required Qty: 1.00

D4577-041

Manufactured No

190

Each

1.0000

1

1

Fwd Access Panel Assembly

SB 13/04/29

Location

Loc Qty

Loc Code

ST237A

1

95275

1

1

~~AN3-6A~~

B# M122814

(4x)

all see 2/12/2013  
u

SB 13/04/30

~~NAS1149D0332]~~

B# M125268

(5x)

SB 13/04/30

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER <del>✖</del>
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

RELEASED  
2012-05-09

D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.05.02		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

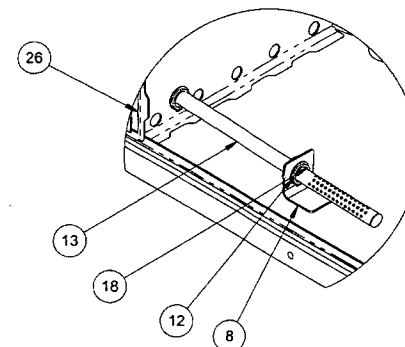
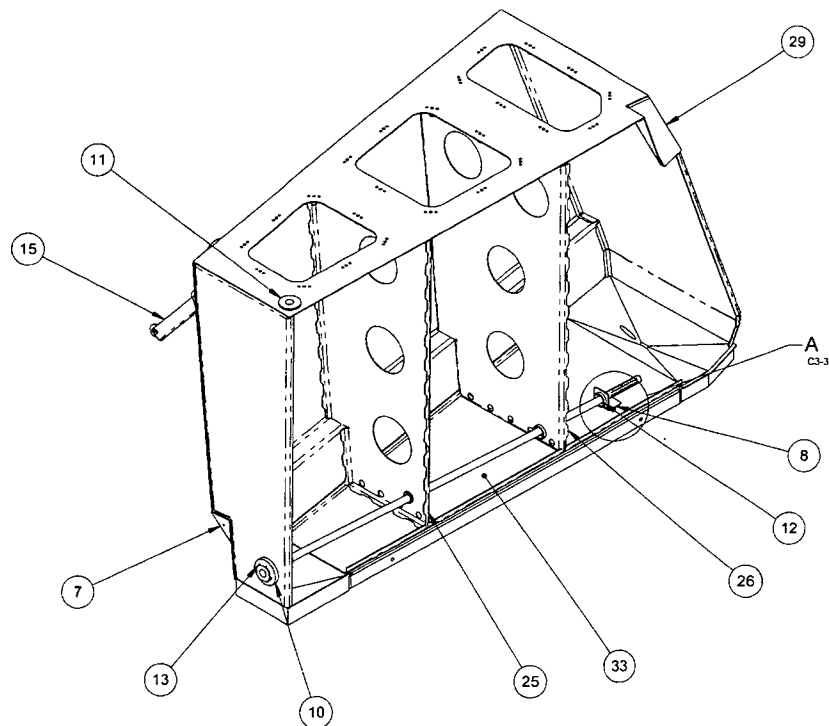
DRAWING NO. **D4464** REV. D  
SHEET 1 OF 5  
TITLE **TANK ASSEMBLY** SCALE NTS

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w/o  
95662







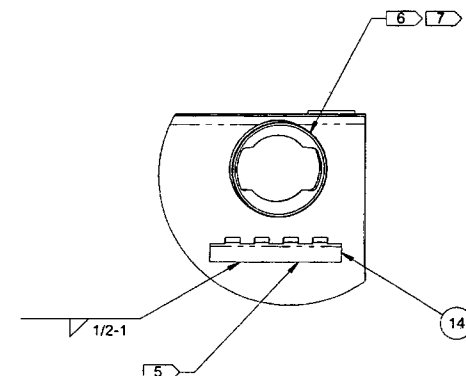
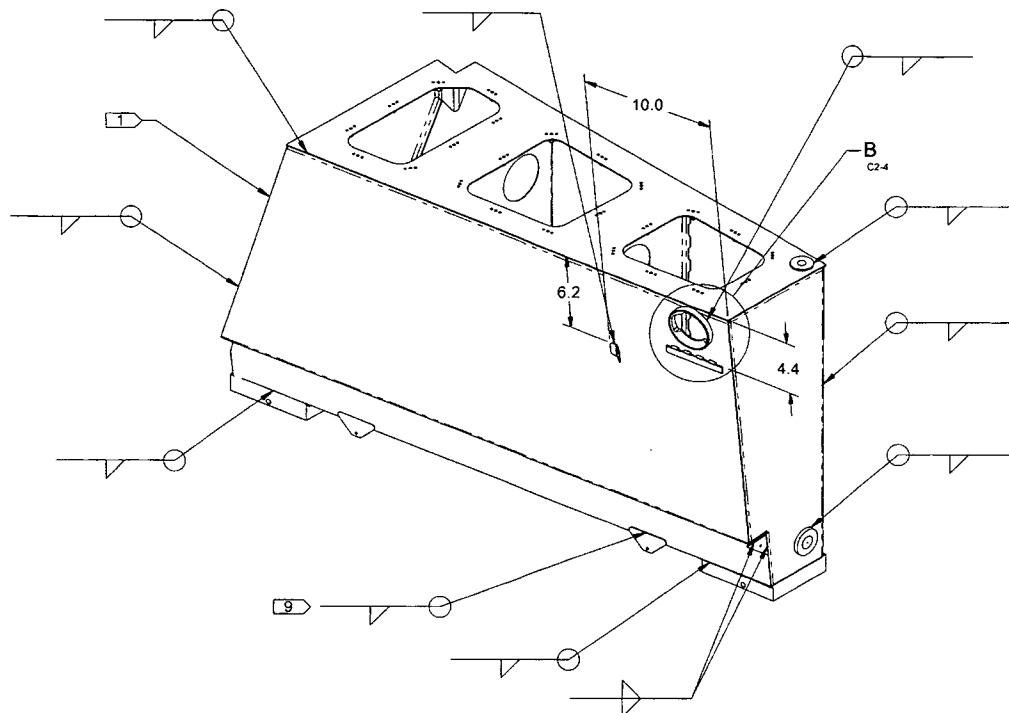
**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-3

**RELEASED**  
2012-05-09  
*W*

**D4464-041 FUEL TANK ASSEMBLY**  
**D4463-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JS</i>	<b>D4464</b>	SHEET 3 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>TANK ASSEMBLY</b>	NTS
DATE	12.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**DETAIL B**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

C2-4

**D4464-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**NOTES:**

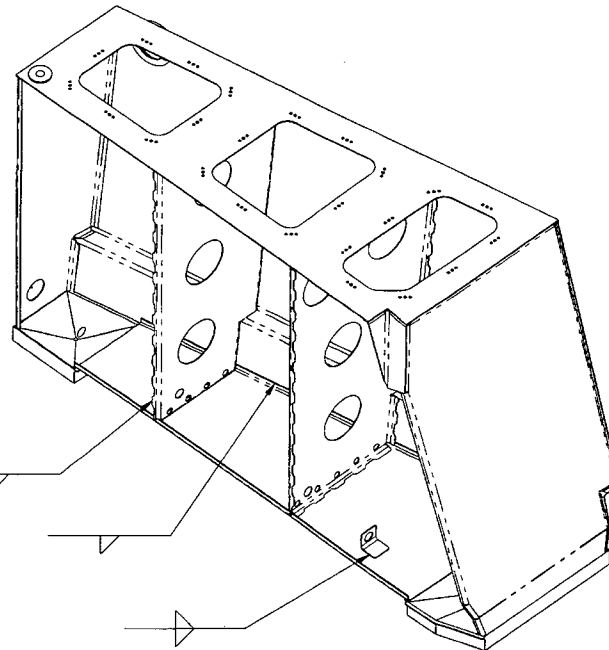
- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING;  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



**RELEASED**  
2012-05-09  
MD

DESIGN	<i>BC</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BC</i>	<b>D4464</b>	SHEET 4 OF 5
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	<b>TANK ASSEMBLY</b>	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

WELD ALL TABS



**D4464-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**RELEASED**  
2012-05-09  
NR

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4464	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



# Picklist Print

Thursday, January 10, 2013 1:46:28 PM

REFERENCE ONLY

Page 9

Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

D4577-3

Middle Access Panel

Manufactured No

190 Each 3.0000

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

## Location

WA003

86086

## Loc Qty

3

3

## Loc Code

190 Each 1.0000

D4577-041

Fwd Access Panel Assembly

Manufactured No

## Location

ST237A

95275

## Loc Qty

1

1

## Loc Code

95275

#AN3-6A

4x M122814

13.02.19

#NAS 1149DO 332 J

5x M122973

13.02.19

13/02/19

13/02/19

Thursday, January 10, 2013 1:46:28 PM

Shop Packet Print

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